

Date: Tuesday, 22/04/2008 3:54:08 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: R/H STEP ASSY
Job Number	: 38764		
Estimate Number	: 13170		
P.O. Number	:	Part Number	: D3724042
This Issue	: 22/04/2008 S.O. No. :	Drawing Number	: D3724 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 38462	Material	:
Written By	:	Due Date	: 12/05/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JLD 08.4.23</u>		
Comment	: Est Rev:A new issue 08-02-07 DD verified by:		
	: Est Rev:B ecn 1154p 08-03-13 DD verified by:		
	: Est Rev:C ecn 1158 08-03-19 DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2622120C	Step Extrusion
-----	-----------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Qty Part # Description Batch:
 1.25 D2622-120C Extrusion 36923

Check Material for any Dents or Defects

SAN 08/04/28 ①

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D3737-2 as per dwg D3737

2-Cut D3738-2 as per dwg D3738

3-Deburr and bevel ends for welding

SAN 08/04/28 ①

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

4.0	D37331	Gusset
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 GUSSET
 batch 338468

SAN 08.05.05 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 3:54:08 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H STEP ASSY

Job Number: 38764

Part Number: D3724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3738-1, D3737-1 and D3733-1 as per dwg D3724

2-Grind flush

08.05.05 1
08.05.05 1

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08.05.05 1

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08.05.05 1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-05 ①

9.0

D2734

Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

206 Step Endplate

batch *B36520*

08.05.05 1

10.0

D37281

Step Bracket



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

PLATE

batch *B38223*

x3

08/05/06
ml

11.0

D37291

Step Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLATE

batch *B38468*

x1

08/05/06
ml

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 3:54:08 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H STEP ASSY

Job Number: 38764

Part Number: D3724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D37301

Angle



B 38600x6



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

ANGLE

batch

B 390530x2

ml

13.0

D37411

Angle



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

ANGLE

batch

B 38490x4

B 38825x4

ml

14.0

MS20470AD511

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

batch

107100

ml

15.0

MS20470AD516

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch

107100

08/05/06

ml

16.0

CR321354

Cherry Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Cherry Rivet

batch

3M107100 = 12 M107139 = 20

08.05.06

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Apply Magnobond before installing rivets

A/R Magnobond 6398 Batch: M104923

2-Rivet D3741-1 and D3730-1 to brackets before installing on step as per dwg D3724

3-Transfer holes from D3730-1 and D3741-1 into step as per dwg D3724

4-Deburr

GA
ml
08/05/06

08.05.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 3:54:08 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H STEP ASSY

Job Number: 38764

Part Number: D3724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Apply magnabond as per dwg D3724

A/R Magnabond 6398 Batch: M104723

6-Rivet brackets in place on step as per dwg D3724

7-Weld both end cap as per Dwg D3724

8-Grind end cap welds flush

Inspect for foreign object per QSI 024

Handwritten notes:
08.05.06 1
08.05.06 1
08.05.07 1
08.05.07 1

18.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

Handwritten: 08/05/07 (X)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/05/07 (X)

#4
35764
D3724042
08/05/2008
S.211 07.55
#1 24.3 F
#2 ---- F
#3 *Comment* F
#4 ---- F

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: 08.05.07

21.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: 08.05.08 (X)

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08/05/08 (X)

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D3043 and QSI 005 4.4

Handwritten: 08/05/08 (X)

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/05/08 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 3:54:08 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R/H STEP ASSY

Job Number: 38764

Part Number: D3724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *PPP*

38764

08/05/13

(C)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08.05.14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

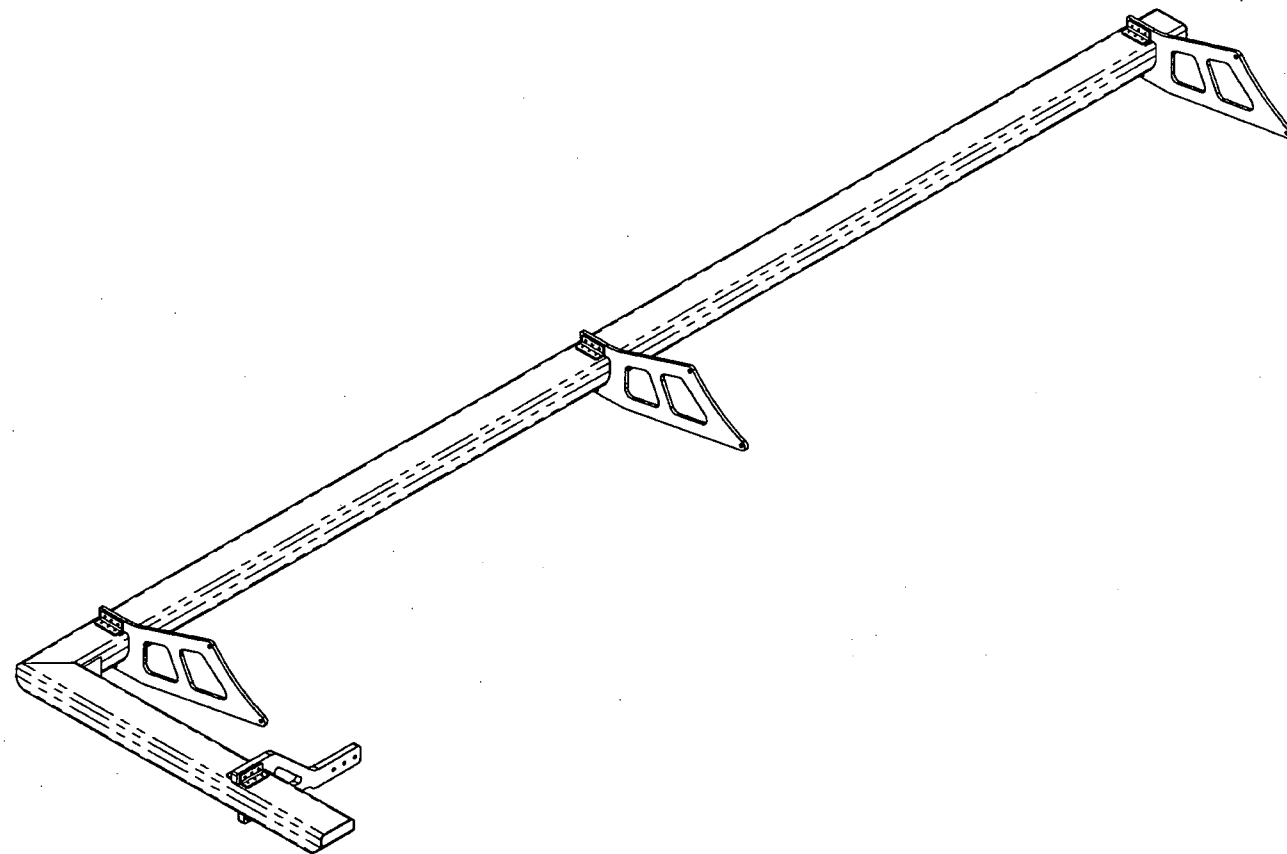
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____


QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

237



D3724-042 STEP ASSY (SHOWN)
D3724-041 STEP ASSY (OPPOSITE) 

NOTES:

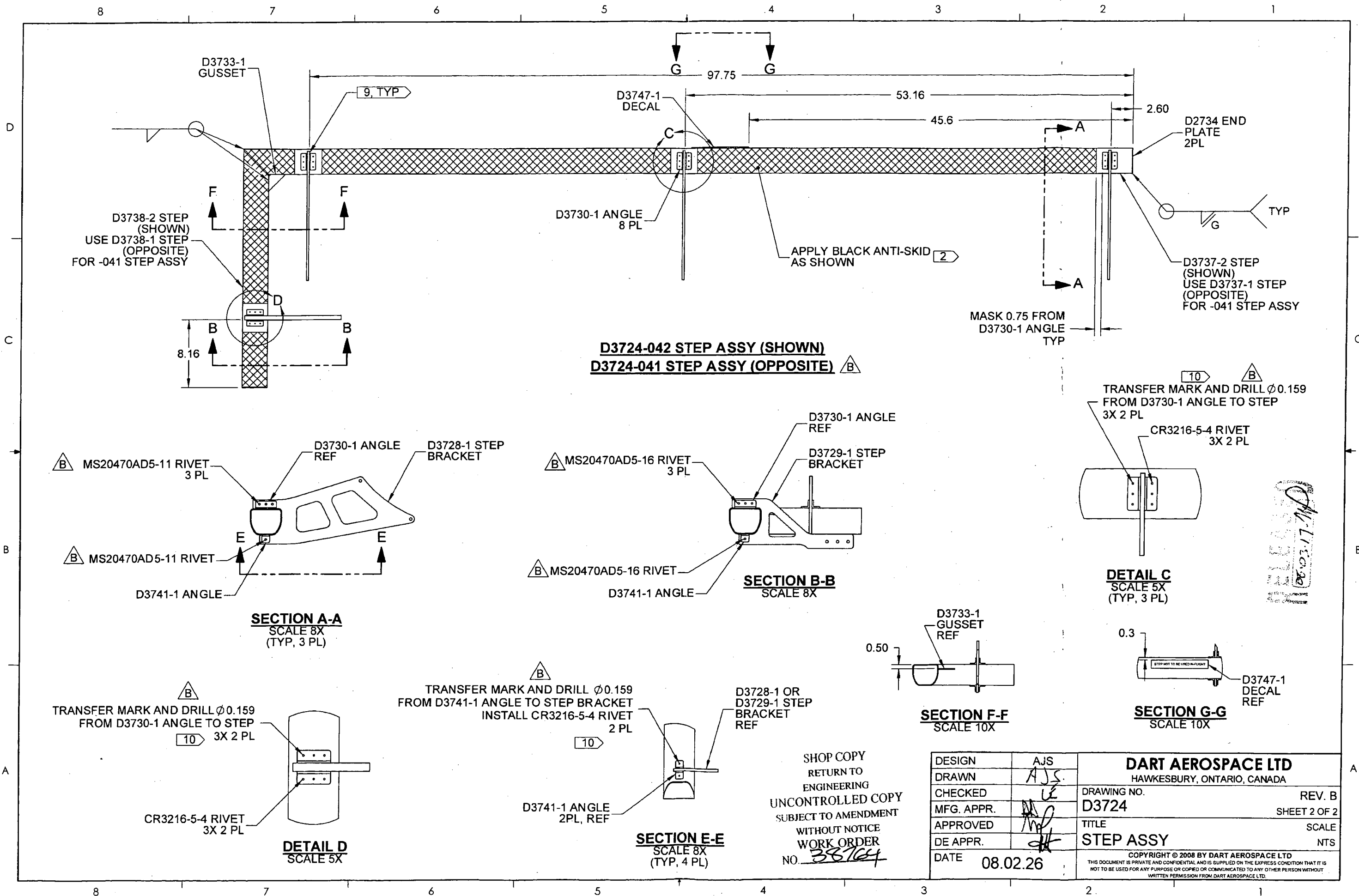
- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT WELDMENT PER DART QSI 005 4.1 PRIOR TO ASSEMBLY
POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PER DART QSI 005 4.4 WHERE INDICATED
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 13.89 lbs
- 8) WELDING: PER DART QSI 004
- 9) APPLY MAGNOBOND 6398 BETWEEN MATING SURFACES WHERE INDICATED
- 10) TOUCH UP CHEMICAL CONVERSION COAT ON ALL PARTS TRANSFER-DRILLED. (REF QSI 005 4.1)

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3724-041	STEP ASSEMBLY
	X	D3724-042	STEP ASSEMBLY
2	2	D2734-1	END PLATE
8	8	D3730-1	ANGLE
1	1	D3733-1	GUSSET
1		D3737-1	STEP
	1	D3737-2	STEP
1		D3738-1	STEP
	1	D3738-2	STEP
1	1	D3747-1	DECAL
32	32	CR3216-5-4	RIVET
12	12	MS20470AD5-11	RIVET
4	4	MS20470AD5-16	RIVET
8	8	D3741-1	ANGLE
3	3	D3728-1	STEP BRACKET
1	1	D3729-1	STEP BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38764

08-03-17/1P

B	ADD -041 ASSEMBLY. ADD D3747-1 DECAL TO P/L SHEET 2 TRANSFER MARKING INSTRUCTIONS FOR INSTALLING D3730-1 & D3741-1 ON D3728-1 & D3729-1 DELETED. SHEET 2 DETAIL C, D & SECTION E-E Ø0.159 WAS Ø0.098. ZONE D4 53.16 DIM WAS 53.22, 2.60 DIM WAS 2.66. ADD SECTION G-G.	AJS	08.02.26
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS.		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MP	D3724	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.		STEP ASSY	NTS
DATE	08.02.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS.		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MD	D3724	SHEET 2 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	STEP ASSY	NTS
DATE	08.02.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	